



Dart Aerospace Ltd.
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D4034-041
Job Sheet 199435



Part No: D4034-041

Job Qty: 4 pcs

Part Name: Aft Upper Rib Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/22/19

Job Tracking No:

Due Date: 9/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC IPP Rev:D 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM IPP REV:E 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	4 pcs	9/9/19	9/9/19	0.00	1.60	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC
							Large Fab - 8		
							Large Fab - 9		Jy
							Large Fab - 11 (Various)		
110	QC 9	4 pcs	9/9/19	9/9/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	8-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	4 pcs	9/9/19	9/9/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19	DAS	
							QC 5 - 22	24	
							QC 5 - 24	8-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S225815



Part: D4034-041

Job No: 199435

Serial No/Batch: S225815

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 18/24/19

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130 Packaging 3-1 - Stock - B4B 4 pcs	9/9/19	0.00 0.00	QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	DAS
			Packaging 3 - 12 - B4B	24
			Packaging 3 - 13 - B4B	9-89
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
140 QC 21 - SA 4 pcs	9/9/19	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 53	9-89

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: 139015) 1- Assemble ribs to hoop and weld as per dwg DT9564 2- Weld
 Descriptions: bushing in rib and grind weld flush as per dwg

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:) LOCATION: WA004-5

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4021-7	Hoop	4 pcs (1 ea)	100-Large Fab - Basket - 1	3K 522040 1x522224
D4021-9	Bushing	16 pcs (4 ea)	100-Large Fab - Basket - 1	5223596
D4034-1	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5215520
D4034-3	Rib	4 pcs (1 ea)	100-Large Fab - Basket - 1	5216430

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4021-7	4	0	0
	D4021-9	16	34	0
	D4034-1	4	22	0
	D4034-3	4	22	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

NCR No. _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐



Job: _____		DISPOSITION		DEPARTMENT/PROCESS				Engineering											
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐											
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)															
Description Work Order Deviation				Disposition				Completed By											
								Lead hand / Supervisor											
								QC / QA Coordinator											
Root Cause				FAULT CATEGORY															
Operator ☐				Pressure/Forced ☐				Contamination ☐				Power Loss/Surge ☐				Positioned Wrong ☐			
Manufacturing Process ☐				Bending ☐				Misaligned/off center ☐				Folio/Program ☐				Outside Tolerance ☐			
Equip/Tooling ☐				Crushing ☐				BOM/Route ☐				Grain Direction ☐				Drawing ☐			
Handling/Preservation ☐				Cracks ☐				Broken/Damage/Defect ☐				Weld ☐				Finish ☐			
Material ☐				Crimp/Kink/Ripple/Wave/Twist ☐				Incomplete/Unclear Instructions ☐				Wrong Stock Pulled ☐				Part Lost/Missing ☐			
Product Improvement ☐				Marks/Chatter ☐				Drill Holes ☐				Out of Sequence ☐				Misread ☐			
Process Improvement ☐				Mislabeled ☐				Fit/Function ☐				Off-set/Set-up ☐							
Human Factors ☐				Other/Details: _____															